



Dart Aerospace Ltd.
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RBT400203
Job Sheet 194183



Part No: RBT400203

Job Qty: 3 pcs

Part Name: Gage Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 7/15/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBT400203 Rev.5 IPP Rev. A 19.01.21 New issue DP Verify DD

Ship Via:

Bill of Materials



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Container No: S194644



Part: RBT400203

Job No: 194183

Serial No/Batch: S194644

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 06/27/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs		7/15/19	0.00	0.60	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs		7/15/19	0.00	0.00	QC 5 - 10		DAS 40 JUL 02 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	3 pcs		7/15/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 JUL 03 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	3 pcs		7/15/19	0.00	0.00	QC 21 - FG - 21		DAS 21 JUL 03 2019 9-89
							QC 21 - FG - 70		
							QC 21 - SA - 53		
Part Op 100 - Assemble as per DWG. See note 1. Descriptions: 110 - See note 1.									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90087A145	Pan Head Screw 6-32 X 5/16	9 Ea (3 ea)	100-Small Fab - 1	3164042
MS20470AD4-6	Rivet, Universal Head	12 Ea (4 ea)	100-Small Fab - 1	- 3166917
MS21042-3	Nut use MS21042L3 per QSI 017	6 Ea (2 ea)	100-Small Fab - 1	3144952
MS24693-S272	Screw	6 Ea (2 ea)	100-Small Fab - 1	3074201
NAS1149F0363P	Washer (AN960-10)	6 Ea (2 ea)	100-Small Fab - 1	3025330
NAS1149FN632P	Washer (AN960-6)	9 Ea (3 ea)	100-Small Fab - 1	3022297
RBT400203-E	Spring	3 pcs (1 ea)	100-Small Fab - 1	3165378
RBT400203-F	Doubler	3 pcs (1 ea)	100-Small Fab - 1	3165374
RBT400203-G	Plastic Bumper	3 pcs (1 ea)	100-Small Fab - 1	3161743
RBT400203-H	Bumper	9 pcs (3 ea)	100-Small Fab - 1	3162390
RBT400203-J	Teflon Tape	3 pcs (1 ea)	100-Small Fab - 1	3165459
RBT400203-K	Weldment	3 pcs (1 ea)	100-Small Fab - 1	3189579

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90087A145	9	92	0
	MS20470AD4-6	12	4,036	0
	MS21042-3	6	537	0
	MS24693-S272	6	597	0
	NAS1149F0363P	6	386	0
	NAS1149FN632P	9	115	0
	RBT400203-E	3	6	0
	RBT400203-F	3	10	0
	RBT400203-G	3	10	0
	RBT400203-H	9	14	0
	RBT400203-J	3	8	0
	RBT400203-K	3	3	0

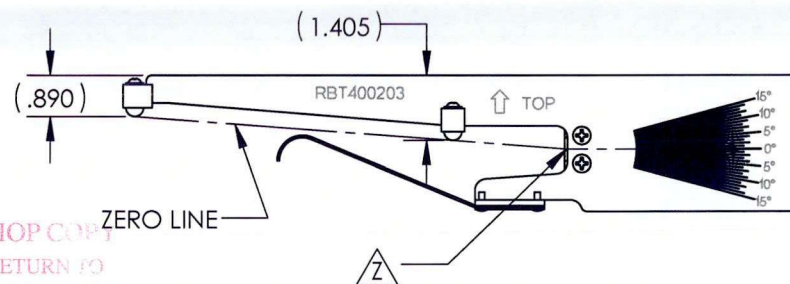
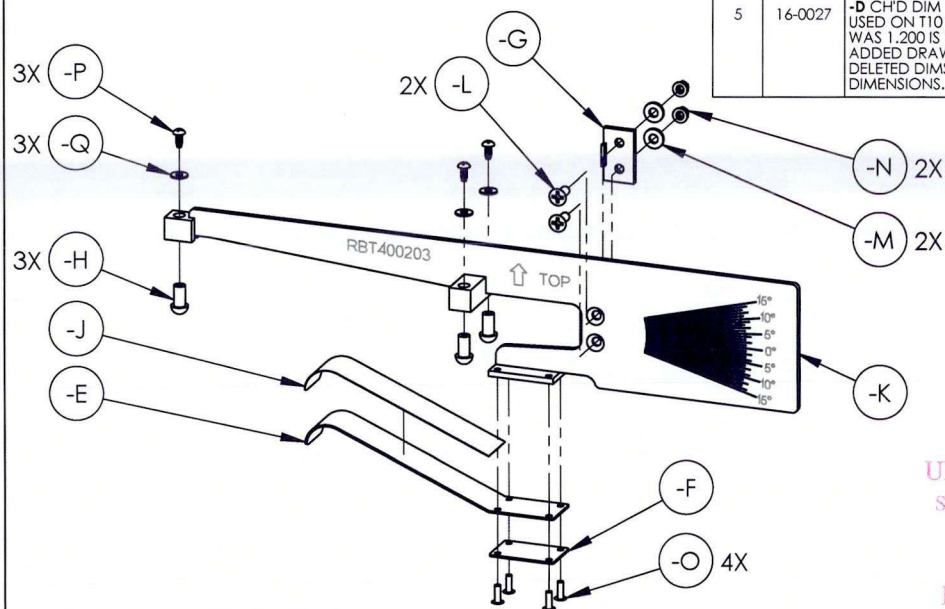
Part Specifications

Specifications could not be found.

Plex 6/27/19 1:53 PM dart.leclair.mathieu

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		INSTALLED NEW TITLE BLOCK & BOM FORMAT, CHANGED P/N FROM 206-215-002-101, AND ALTERED FROM ONE 11x17 PAGE TO THREE 8x11 PAGES, ALSO CHANGED FROM MIL SPEC HARDWARE.	8/28/2007	WP	RW
2		ADDED OUTSIDE RADIUS TO -E AND -F.	1/9/2008	WP	RW
3		REMOVED -E FLAT LAYOUT AND SUPPLIED MISSING OVER ALL DIMENSION.	4/20/2009	WP	RW
3A		DELETED ASSY NOTES 1 & 2, ADDED -K WELDMENT TO BOM, CH'D WELDMENT FROM -A WELDMENT, DELETED NOTES 1, 2, & 3, CH'D FINISH FROM P.C. SAFETY YELLOW, MOVED PARTS TO SEPARATE SHEETS PER R.W.	8/11/2011	RJC	RW
4		-E ADDED +/- .030 LIMITS TO DIMS (1.50, 5.76, .54, R.5), ADDED MISSING ANGLE DIM 22°. -B CH'D DIM WAS .125 IS .126 +.005/-0.000. -A CH'D COUNTERBORE CALLOUT WAS 82° IS 82° X Ø.375. -K ADDED .515 DIM.	2/13/2013	BIM	SE
5	16-0027	UPDATED TO NEW STANDARDS. -A CH'D DIMS WAS 2X Ø.188 THRU 82° X Ø.375 IS 2X Ø.196 THRU ALL Ø.39 X 100°. WAS 3X R.250 IS 4X R.25. ADDED ENGRAVE S/N, "MADE IN USA" NOTE. -B CH'D DIMS WAS Ø.250 IS Ø.2500-.2509, WAS .126 +.005-.000 IS .142-.150. -C CH'D DIMS WAS 2X Ø.250 IS 2X Ø.2500-.2509, WAS .126 +.005-.000 IS .142-.150, WAS .69 IS .68, WAS 1.500 IS 1.50. ADDED DIM 2X .25. -D CH'D DIM WAS .125 IS .13. -E CH'D TO SHEET METAL TOLERANCES. DELETED SAME SPRING CLIP USED ON T101656 NOTE. -F CH'D DIMS WAS .150 IS 2X .150, WAS .700 IS 2X .700, WAS .150 IS 2X .150, WAS 1.200 IS 2X 1.200. -G CH'D DIM WAS .372 IS 2X .372. -H CH'D DIM WAS Ø.252 IS Ø.2484-.2490. -J ADDED DRAWING. ADDED B/O REF PORT PLASTICS #6093-10. -K CH'D DIM WAS 1.00 IS (1.00). DELETED DIMS .515, .250, .250, 2.000, 5.00. ADDED DIM .44. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	2/9/2016	DPD	SM



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NOTE:
1. POINT Δ IS ALSO CENTER LINE FOR 0°, AND CENTER POINT FOR DEGREE ARC.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	1		-A		GAUGE PLATE	6061		3
	1		-B		END BEARING PLATE	6061		4
	1		-C		DOUBLE BEARING PLATE	6061		5
	1		-D		SUPPORT PLATE	6061		6
			-E	1	SPRING CLIP	301 S.S.		7
			-F	1	DOUBLER	301 S.S.		8
			-G	1	STOP	WHITE DELRIN/ACETAL		9
			-H	3	BEARING	WHITE DELRIN/ACETAL		10
			-J	1	TEFLON TAPE	TEFLON	1" (PORT PLASTICS #6093-10) MODIFIED	11
	X		-K	1	WELDMENT GAUGE PLATE			2
		B/O	-L	2	FLAT HEAD MACHINE SCREW	STEEL	10-32 X 1/2 (MS24693S272)	1
		B/O	-M	2	FLAT WASHER	STEEL	#10 (AN960-10)	1
		B/O	-N	2	SELF LOCKING NUT	STEEL	10-32 (MS21042-3)	1
		B/O	-O	4	RIVETS	ALUMINUM	Ø1/8 X 3/8 (AN470AD-4-6)	1
		B/O	-P	3	SELF THREADING PAN HEAD SCREW	STEEL	6-32 X 5/16, TYPE F (MCMaster-CARR #90087A145)	1
		B/O	-Q	3	FLAT WASHER	STEEL	#6 (AN960-6)	1
	ASSY -K							

		TITLE		TRIM TAB BENDING GAUGE	
		DWG NO.		RBT400203	
		REV		5	
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8			
FINISH		.XX ± .01 ANGLES ± 5°			
SPEC		.X ± .1 SURFACES = 125/✓			
DRAWN BY:		COLE			
CHECKED:		CLOUGH			
OPPS APPR:		ANDERSON			
QA APPR:		LINDSAY			
APPROVED:		MACKOVJAK			
SCALE		1:4		DATE 1/10/2002	
				SHEET 1 OF 11	